

Date: Friday, 11/04/2008 11:07:27 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR WEDGE
Job Number	: 38526		
Estimate Number	: 12111		
P.O. Number	:	Part Number	: D32003
This Issue	: 11/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3200 REV A
First Issue	: 11/04/2008	Project Number	: N/A
Previous Run	: 36754	Drawing Revision	: A
		Material	:
Written By	:	Due Date	: 17/04/2008
Checked & Approved By	: <u>JD</u> <u>08-4-11</u>	Qty:	42 Um: Each
Comment	: Est Rev:A Removed from 9 Digit 06-01-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.0158 sf(s)/Unit Total: 0.6300 sf(s)

UHMW 1" Black

Material: Black UHMW 0.95" or 1.00" thick

Use bearpaw scrap material

(MUHMWB10)

Identify for D3200-1

Batch: M107067

N.A

08/04/12

(42)

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank: 1.000 X 1.800"

N.A

08/04/12

(42)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine D3200-3 as per Folio FA337 and Dwg D3200

2-Deburr

N.A

08/04/12

(42)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

N.A

08/04/12

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/04/2008 11:07:27 AM
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Drawing Name: DOOR WEDGE

Job Number: 38526

Part Number: D32003

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/04/14

(42)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Lu 8/4/14 (42)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/16

Job Completion



MF 08-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

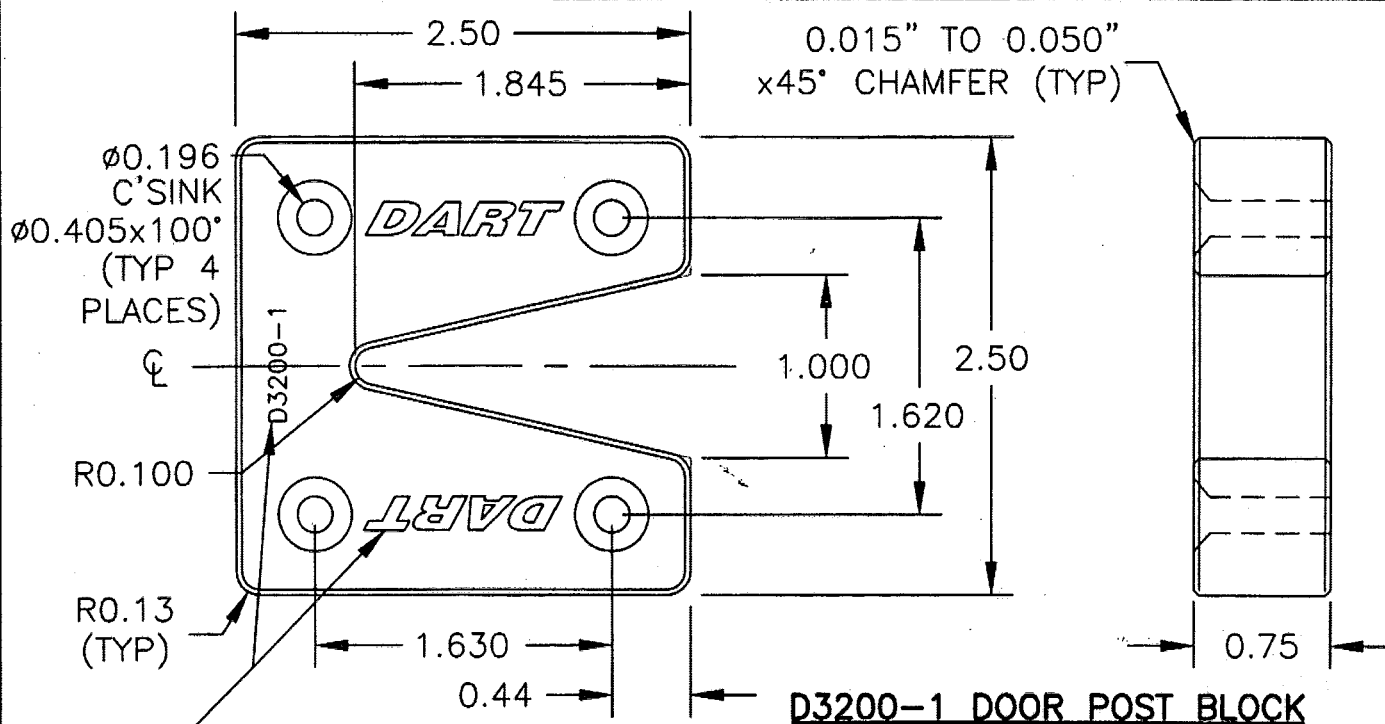
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

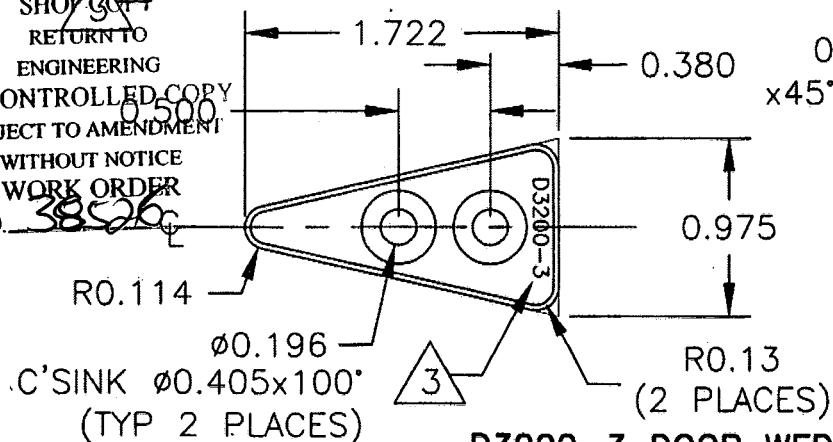
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06		TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06	NEW ISSUE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38526



D3200-3 DOOR WEDGE

D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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